

Work Order ID 69120

Monday, May 02, 2011 2:07:47 PM



Page 1

Item ID: D3437-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Strut Assembly

Start Date: 5/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 11-05-2

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3437

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3437Dwg Rev: *B**SB 11/05/02**(L)*

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8 11/05/02**(K)*

120

0.00

Identify as per dwg & Stock Location: *508*

Packaging

Memo

0.00

Packaging

11/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69120

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Page 2

Item ID: D3437-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Strut Assembly

Start Date: 5/2/2011 Start Qty: 1.00

Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CKU/05/02

MF
11-05-02

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NOTE: Date & initial all entries

Picklist Print

Monday, May 02, 2011 2:07:43 PM

Page 1

Work Order ID: 69120

Parent Item: D3437-043

Parent Item Name: Aft Strut Assembly



Start Date: 5/2/2011

Required Date: 5/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 05.05.20 New Issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C516 WASHER		Purchased	No			100	Each	54.0000	2	2			
<div> <div>Location</div> <div>ST347</div> <div>102842</div> </div> <div> <div>Loc Qty</div> <div>54</div> <div>54</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3437-1 Foot		Manufactured	No			100	Each	16.0000	1	1			
<div> <div>Location</div> <div>ST508</div> <div>44787</div> <div>46046</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>4</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3437-3 Clip		Manufactured	No			100	Each	42.0000	1	1			
<div> <div>Location</div> <div>ST508</div> <div>43175</div> </div> <div> <div>Loc Qty</div> <div>42</div> <div>42</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3437-9 Eyebolt		Manufactured	No			100	Each	11.0000	1	1			
<div> <div>Location</div> <div>ST508</div> <div>43815</div> <div>44790</div> </div> <div> <div>Loc Qty</div> <div>11</div> <div>3</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

SS 11/05/02

2

SS 11/05/02

1

SS 11/05/02

1

SS 11/05/02

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, May 02, 2011 2:07:43 PM

Page 2

Work Order ID: 69120



Parent Item: D3437-043



Parent Item Name: Aft Strut Assembly

Start Date: 5/2/2011

Required Date: 5/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-5

Purchased

No

100

Each

540.0000

1

1



SS 11/05/02

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

520

112314

420

116548

100

1

W/O:		WORK ORDER CHANGES					
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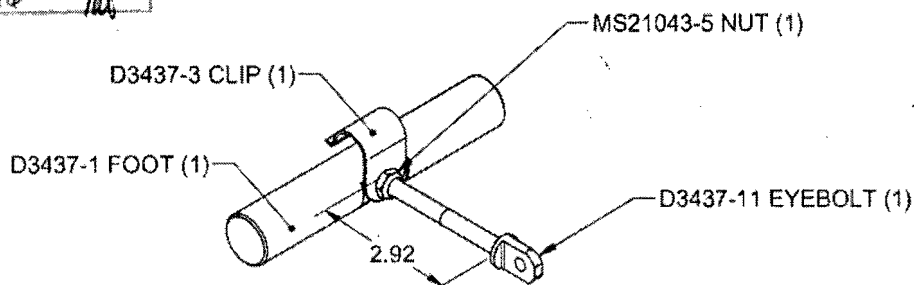
NOTE: Date & initial all entries



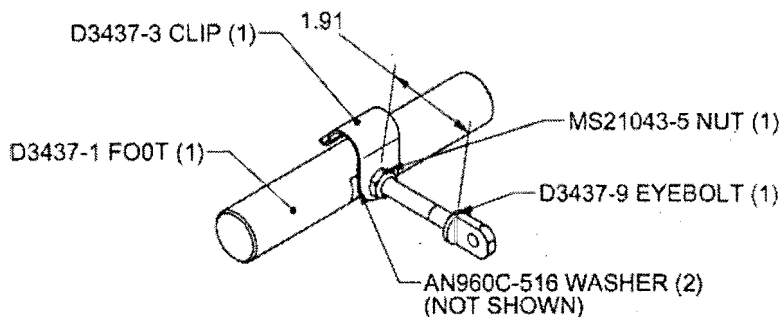
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 1 OF 4
DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED

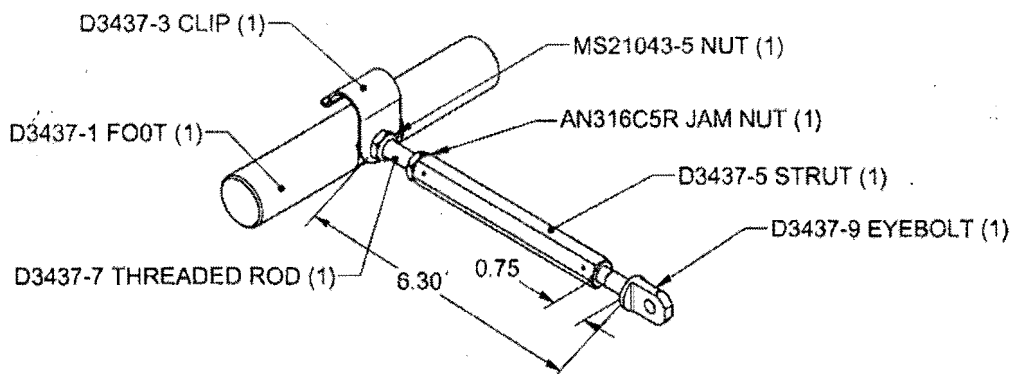
05.08.16 *[Signature]*



D3437-041 AFT STRUT ASSEMBLY



D3437-043 AFT STRUT ASSEMBLY



D3437-045 AFT STRUT ASSEMBLY

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

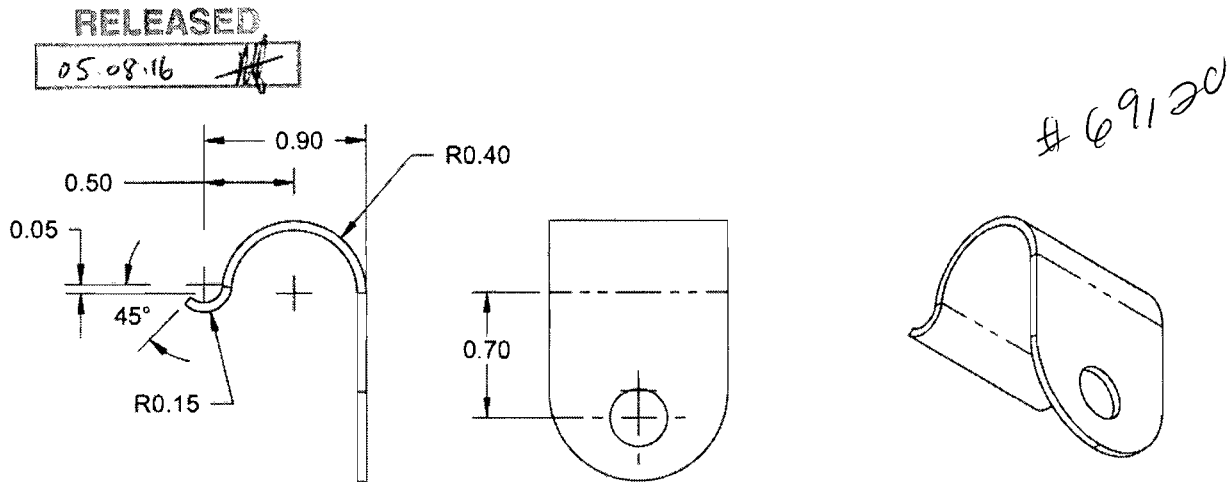
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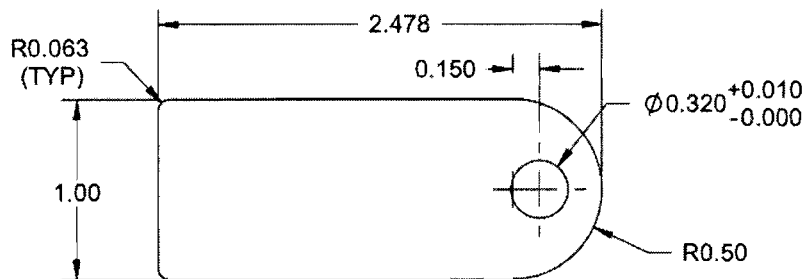
NOTE: Date & initial all entries



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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2



D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

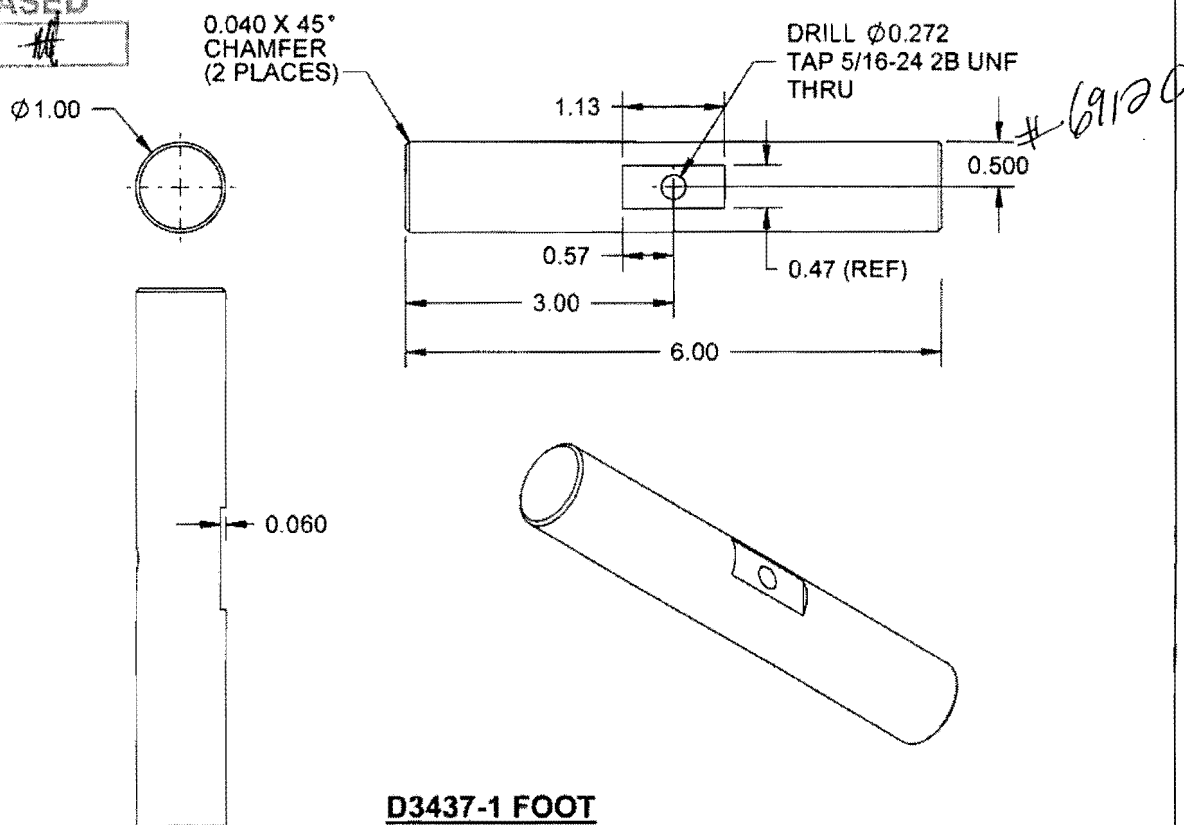
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 3 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

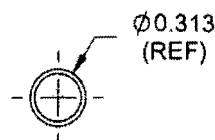
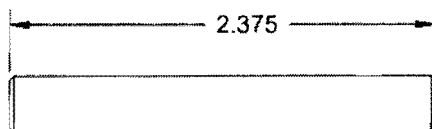
RELEASED

05-08-16 *[Signature]*



D3437-1 FOOT:

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR
(REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



D3437-7 THREADED ROD

D3437-7 THREADED ROD:

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

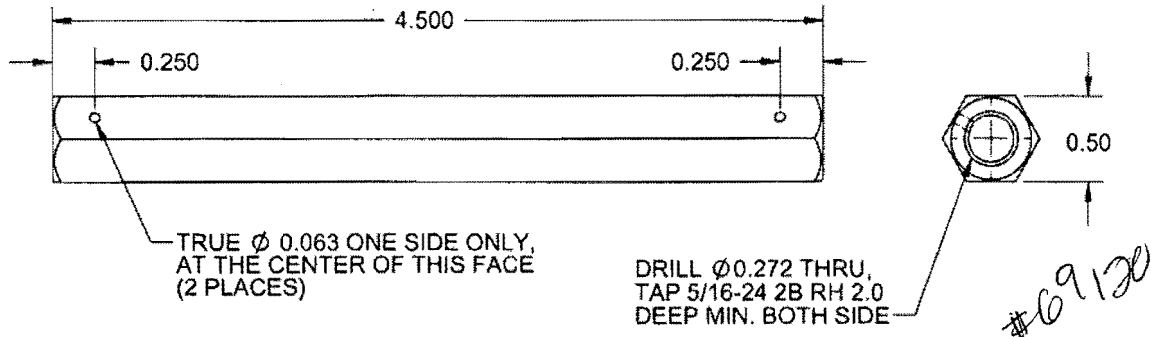
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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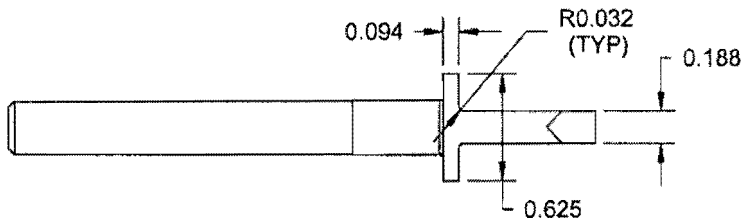


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 4 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2



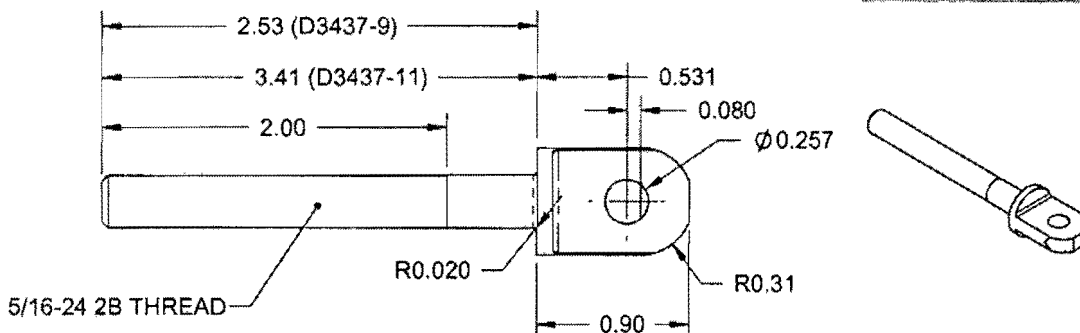
D3437-5 STRUT:

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



RELEASED

05-08-16 *[Signature]*



D3437-9/-11 EYEBOLT:

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries